

Work Order ID 58768

May 18, 2010 1:45:44 PM



Page 1

Item ID:	D3121-144	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Bracket Assembly					
Start Date:	5/18/10	Start Qty:	10.00		Cust Item ID:	
Required Date:	5/28/10	Req'd Qty:	10.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	Tooling:	Date:	Run	Start	
	QC:		Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3121	Rev E								

100		BAND SAW	0.00			10			
	Bandsaw	Memo	0.00						
	Jeaspa Bandsaw	Cut blanks: (1.250" x 2.000") 4.425" long							
110		HAAS CNC VERTICAL MACHINING #1	0.00			10	1		
	HAAS 1	Memo	0.00						
	HAAS CNC vertical machine #1	1-Machine D3121-114 as per Folio FA330 and Dwg D3121 Identify as D3121-114□2-Deburr□3-Scribe batch number							
120		QC2- Inspect parts off machine FAI/FAIB	0.00			10	1		
	QC	Memo	0.00						
	Quality Control								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3121-144 PAR #: _____ Fault Category: machining NCR: (Yes) No DQA: [Signature] Date: 10/05/21
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: [Signature] Date: 10/05/26

NCR: 58768		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/05/21	110	1 part Scrap Ø0.392 ^{+0.002} _{-0.000} Spigots are 0.383" offset adjustment was incorrect when entered: 1440 R.C. Operator Error	<u>[Signature]</u>	Scrap and Replace B# 113568	<u>[Signature]</u> 10/05/21	LF 10/05/21	<u>[Signature]</u> 10/05/21	<u>[Signature]</u> 10/05/21

NOTE: Date & initial all entries

Work Order ID 58768

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Item ID: D3121-144

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket Assembly

Start Date: 5/18/10 Start Qty: 10.00



Cust Item ID:

Required Date: 5/28/10 Req'd Qty: 10.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

10/05/21

10

1

140



Small Fab

Small Fab

Small Fab

0.00

Memo

0.00

Assemble D3121-143 as per Dwg D3121.

10/05/26 *(10)*

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8/10/16

(+10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 58768

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Item ID: D3121-144

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket Assembly

Start Date: 5/18/10 Start Qty: 10.00



Cust Item ID:

Required Date: 5/28/10 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	Identify as per dwg & Stock Location: <u>235N</u>	0.00							
Packaging	Memo	0.00							
Packaging									
170 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

10-5-26

QXSP

10/05/26

C21015/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 58768

Parent Item: D3121-144

Parent Item Name: Bracket Assembly

Comments: IPP Rev:Pick:A 04.02.18 New issue KJ/DS
IPP Rev:B ECN 1060 07-11-12 DD verified by:EC
IPP Rev:C New Dimensions for Blank Size 08-07-23 JLM Verified By:EC


Start Date: 5/18/10

Required Date: 5/28/10

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Qty	Date	Status
--------------------	-------------	------	-----	---------	------	-------	---------	--------	-------------	-----	------	--------

D3121-21		Manufactured	No			140	Each	23.0000	2			
												
Bolt												

B59044

18/05/26
28/05/26

Location	Loc Qty	Loc Code
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ST235	23	
57376	23	

D3121-241		Manufactured	No			100	Each	42.0000	2			
												
Bearing Assembly												

Location	Loc Qty	Loc Code
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ST235B	42	
55005	2	
56419	40	

M174B1.250X02.000		Purchased	No			140	f	14.7894	0.368			
												
17-4 SS Bar 1.250 x 2.00												

Location	Loc Qty	Loc Code
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MAT031	14.7894	
113568	14.7894	

3.8719
 +
 0.3872
 Total = 4.2591 (f)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	58768
Description: Bracket		Part Number:	D3121-114
Inspection Dwg: D3121 Rev: E		Page 1 of 2	

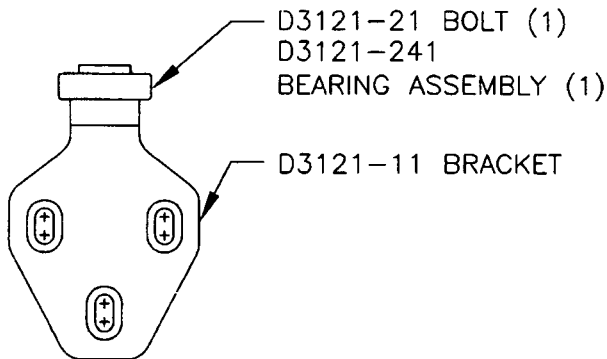
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

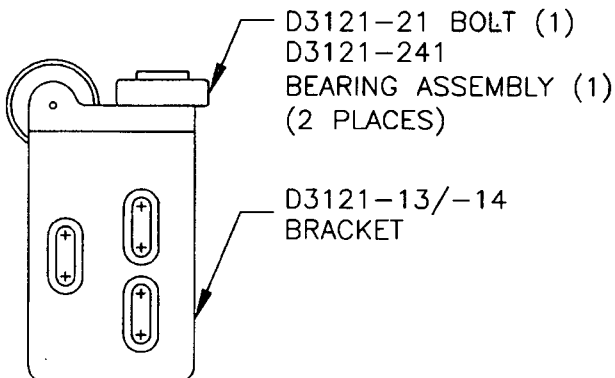
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.080	+/-0.010	0.084	✓			
0.300	+/-0.010	0.299	✓			
R0.375	+/-0.010	0.375	✓			
1.54	+/-0.030	1.54	✓			
0.350	+/-0.010	0.350	✓			
R0.25	+/-0.030	0.25	✓			
Ø0.392	+0.002/-0.000	0.394	✓			
Ø0.201	+0.005/-0.000	0.201	✓			
0.100	+/-0.010	0.100	✓			
2.540	+/-0.010	2.534	✓			
1.590	+/-0.010	1.588	✓			
0.160	+/-0.010	0.154	✓			
0.400	+/-0.010	0.403	✓			
1.220	+/-0.010	1.219	✓			
1.600	+/-0.010	1.601	✓			
3.80	+/-0.030	3.805	✓			
1.800	+/-0.010	1.803	✓			
R0.50	+/-0.030	0.50	✓			
0.130	+/-0.010	0.128	✓			
3.41	+/-0.030	3.400	✓			
3.65	+/-0.030	3.637	✓			
2.24	+/-0.030	2.21	✓			
45°	+/-0.1°	45°	✓			
R0.25	+/-0.030	0.25	✓			
3.97	+/-0.030	3.962	✓			
R0.38	+/-0.030	0.38	✓			
Ø0.392	+0.002/-0.000	0.394	✓			
Ø0.201	+0.005/-0.000	0.201	✓			
0.268	+/-0.010	0.268	✓			
R0.260	+/-0.010	0.260	✓			
0.080	+/-0.010	0.082	✓			
0.300	+/-0.010	0.298	✓			
0.381	+/-0.010	0.388	✓			
0.201	+/-0.010	0.207	✓			

DART

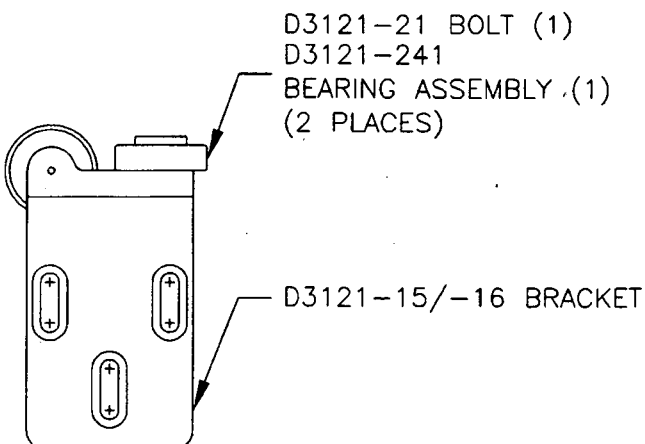
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CHECKED <i>A</i>	APPROVED <i>A</i>	DRAWING NO. D3121	REV. E SHEET 1 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2
A	02.04.15	NEW ISSUE	
B	03.01.16	ADD RIDGES; ADD MAT'L PROP; FIX P/N ADD -141/-143/-144/-145/-146	
C	04.02.17	ADD CLEARANCE; USE -241 BEARING	
D	06.05.17	D3121-25 CAP WAS 1.024, NOW 1.000	
E	07.11.07	ADD TOLERANCE TO 0.032 (DETAIL B)	

RELEASED
07.11.07

D3121-041 BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-33)

w/ 58768

D3121-043 (SHOWN) / D3121-044 (OPPOSITE) BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-37/-38)



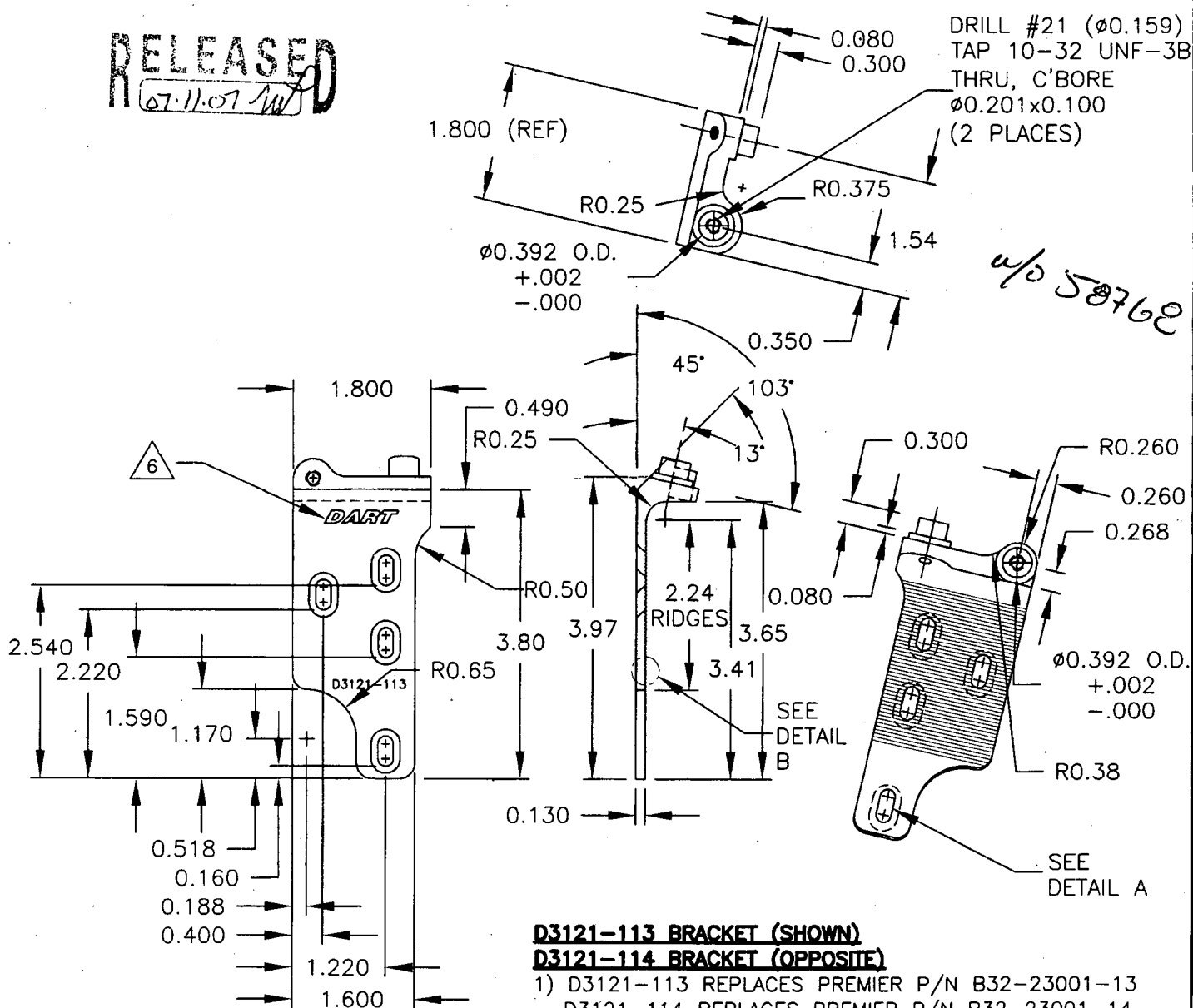
D3121-045 (SHOWN) / D3121-046 (OPPOSITE) BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-35/-36)

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DART

DESIGN #	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3121	REV. E SHEET 8 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2

RELEASED
07.11.07**D3121-113 BRACKET (SHOWN)****D3121-114 BRACKET (OPPOSITE)**

- 1) D3121-113 REPLACES PREMIER P/N B32-23001-13
D3121-114 REPLACES PREMIER P/N B32-23001-14
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE STRENGTH = 150 ksi
MIN YIELD TENSILE STRENGTH = 100 ksi
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

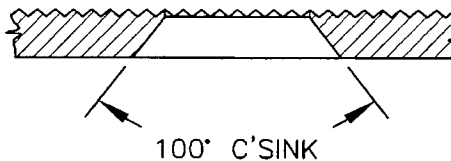
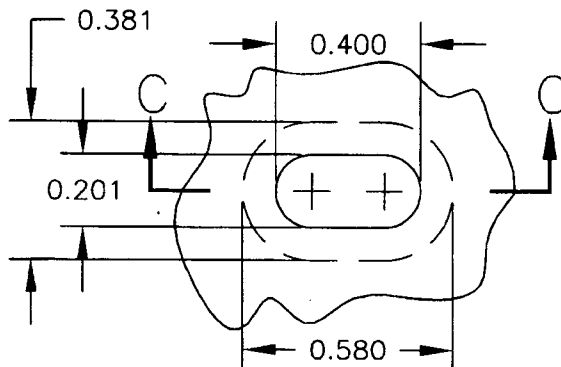
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DESIGN #	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3121	REV. E SHEET 3 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:1

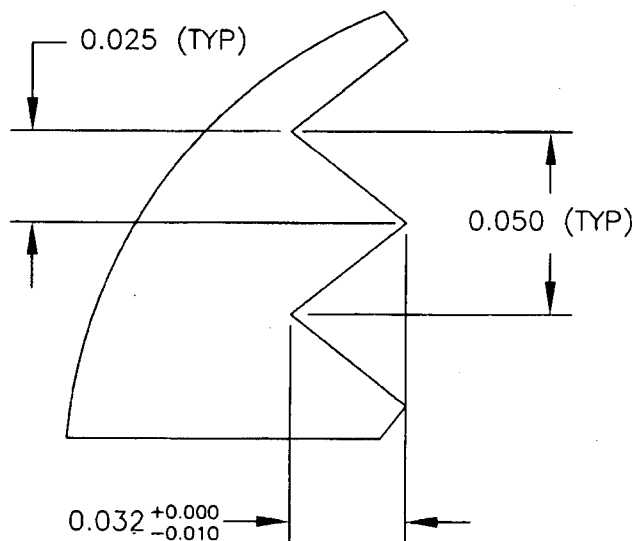
DETAIL A:
SLOT DETAIL
SCALE 2:1
VIEW ROTATED



SECTION
C-C

RELEASED
07.11.07 / WP

DETAIL B:
RIDGE DETAIL
PARTIAL SECTION
SCALE 1:20



w/058768

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